



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3969-5
Job Sheet 166696



Part No: D3969-5

Job Qty: 1 ea

Part Name: Spring (Basket Lid)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/13/17

Job Tracking No:

Due Date: 10/16/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP Rev:A new issue DD 10.03.16 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
100	Purchasing	1 pcs	10/16/17			LST001-VC	
110	Packaging	1 pcs	10/16/17	0.00	0.00	Packaging2	DA
120	QC	1 pcs	10/16/17	0.00	0.00	QC6	38
122	Small Fab	1 pcs	10/16/17	0.00	0.00	Small Fab	9-88 DA
124	QC	1 pcs	10/16/17	0.00	0.00	QC5	38
130	Packaging	1 pcs	10/16/17	0.00	0.00	Packaging3	51364 9-88
140	QC21-SA	1 Ea	10/16/17	0.00	0.00	QC21	21 NOV 06 2017

Part Op 100 - Issue P/O: 03836 Order as per Dwg D3969 Possible supplier: LS Technologies part#: SSA4/6-122-
Descriptions: 315-133N Material release note is required

110 - ***Measure compression only at 5mm on gas spring***

122 - CRIMP END FITTING AT LOCATION SHOWN ON DWG (SEE NOTE 8) ***IF NOT MADE BY VENDOR***

OCT 13 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	SSA4/6-122-315-133N	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/13/17 1:23 PM dart.poulin.mario

DQA: _____ Date: _____



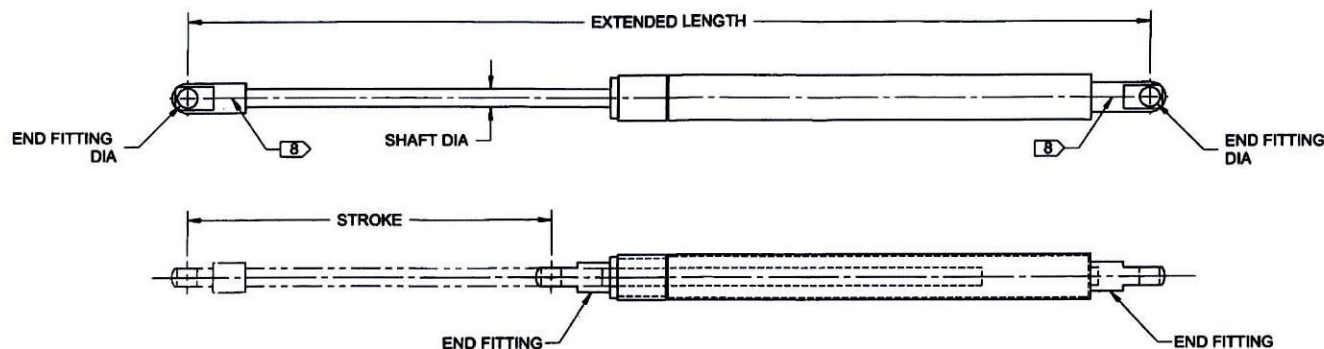
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	122/4.80	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	122/4.80	315/12.40	8/0.31	380/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	122/4.80	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs
D3969-7	122/4.80	315/12.40	6/0.24	222/50.0	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-225N	0.27 lbs
D3969-9	130/5.12	343/13.50	8/0.31	380/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-130-343-360N	0.35 lbs

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 1666161D

OCT 12 2017

RELEASED
2016-05-19
6-581

D	ADDED -7/-9	ML	16.05.12
C	REDRAWN IN SW, ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs).	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	08.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3969	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET LID SPRING	NTS
DATE	16.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038036

Supplier: LST001-VC
LS Technologies Inc.
314 Jessop Ave
Saskatoon
SK
S7N 1Y6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO038036
PO Date: 10/13/17
Due Date: 10/18/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

OCT 13 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	SSA4/6-122- - 315-133N				Gas Spring D3969-5 DWG REV C		Firmed	10/18/17	1 Ea	0 Ea	1 Ea	\$0.00001/Ea	\$0.00

Line Item Note B166696

Grand Total: \$0.00

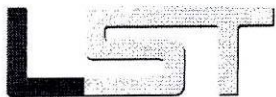
Order Notes

DWG REV C

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

Plex 10/13/17 2:28 PM dart.lavoie.chantal



LS TECHNOLOGIES INC
1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

Packing Slip

P.O. No.	Date	Invoice #
37627	10/13/2017	17330

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
10/13/2017	UPS	

Qty	Description
1	D3969-5 B165837 Stainless Gas Spring (SSA4/6-122-315-133N) 30 Lb Force LABELLED WITH PERMANT INK MARKER ONLY - NO LABELS WARRANT REPLACEMENT Shipping - UPS - AIR - Tracking # 1ZV659Y21459764892 SPA-10-18

Order checked by :



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

Oct 13, 2017

This is to certify that the parts listed below meets specifications as required by your order.

**1 Units : D3969-5 B165837 Stainless Gas Spring (SSA4/6-122-315-133N)
LABELLED WITH PERMANT INK MARKER ONLY - NO LABELS**

WARRANT REPLACEMENT

**Country of Manufacture: Canada
Date of Manufacture: Octt 2017
This product is ROHS compliant.**

Purchase Order # 37627
Inv# 17330

L S Technologies Inc Canada

A blue ink signature of Nolan Fehr, written in a cursive style, positioned above a horizontal line.

Nolan Fehr
President

S000882



PART NO: D3969-5

Revision:

Operation: Purchasing

Quantity: 1

Change No:

Mfg Date: 10/18/17

Job No: 166696